

Wednesday, October 05, 2016 3:08:48 PM

646.3811

151651

Page 1

Revision ID:

Item Name: Radius Block

Start Date: 9/27/2016 **Start Qty:** 10.00

10

Required Date: 10/19/2016 **Req'd Qty:** 10.00

10

N900040100

Setup Start *NS1*

Stop *NS2*

Reference:

Approvals: Process Plan: **DAS** Date: **OCT 06 2016**
21

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

646.3800

N/C

110

Manufacture as per dwg

0.00

110

Mill Conv

Conventional Milling Machine

Memo

1-Machine per DWG
DWG REV: *N/C*

0.72

2- deburr and break all sharp edges

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.02

DAS
32
9-89

16-10-13

DAS
32
9-89

16-10-13

Work Order ID 151651

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151651

Page 2

Item ID: 646.3811 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Radius Block
Start Date: 9/27/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	QC8- Inspect parts - second check	0.00							
130									DAS
QC	Memo	0.03				10	0		08
Quality Control									9-89

140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									DAS
Outsource4	Memo	299.99				10			13
Outsource process - Anodize	Issue P/O to ATG : <u>34063</u>								6-89

1- Black Anodize as per Dwg 646.3800
2- PRIME AS PER DWG, SEE NOTE #2
Certification of Comformity is required

150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									DAS
Packaging	Memo	0.03				10x			26
Packaging									9-89

NOV 11 2016

Work Order ID 151651

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151651

Page 3

Item ID: 646.3811 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Radius Block
Start Date: 9/27/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155 *155* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				<u>10</u>			DAS 38 9-89 NOV 11 2016
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>CC-H100</u> Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00 0.02				<u>10</u>		NOV 14 2016	DAS 6 9-89
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.17				DAS 21 9-89		NOV 15 2016	DAS 21 9-89 NOV 14 2016

Picklist Print

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Page 1

Work Order ID: 151651

151651

Parent Item: 646.3811

646 3811

Parent Item Name: Radius Block

Start Date: 9/27/2016

Required Date: 10/19/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.000X00.25 0		Purchased	No				f	4.0520		1.473684			
M7075T6B1 000X00 250													DAS 32 9-89
7075-T6 BAR 1.000' X 0.250"												16-10-13	

Location

Loc Qty

Loc Code

MAT005

4.052

m130312

4.052

2.6931

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03697				SHEET 1 OF 1	
	DWG NO. 646.3800	REV: N/C	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKETS					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>David Baker</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL.				ECR: D-12-006	

IS

1 PRIMARY MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

SHEET 1, ZONE A2 IS:

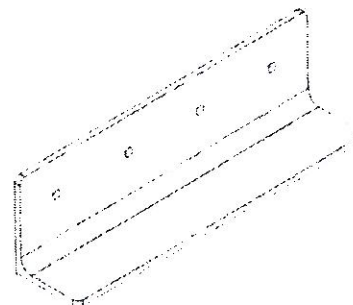
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151651 MJS
16-10-06

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BDM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

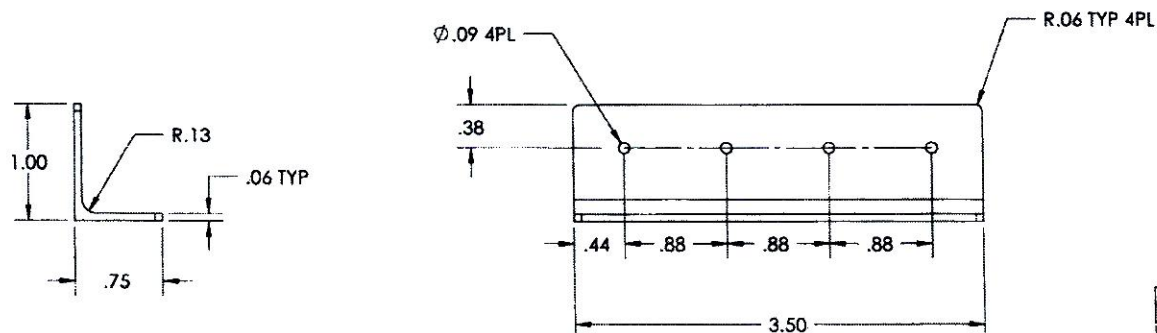
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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



646.3810



UNINCORPORATED E.C. (3)

036097

		646.3814	WIPER BRACKET	△	△
		646.3813	STRUT BRACKET	△	△
		646.3812	GUSSET BRACKET	△	△
		646.3811	RADIUS BLOCK	△	△
		646.3810	BRACKET	△	△
	QTY FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY	
NEXT ASSY IS:	ORIGINAL DATE: 05-19-05
646.4000	DRAWN BY: J. GARDNER
	CHECKED BY: P. BAYO
	DIMENSIONS APPROVAL: P. BAYO (05/19/05)
	CONTRACT NO:
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.010 1 PLACE DECIMALS ±.015 ANGLES ±.5°

PARTS LIST	
APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR.	
OCEANSIDE, CA. 92056-3512 (760) 724-5300	
BRACKETS	
EST. CODE CODE:	DWG. NO:
B 07/14/6	646.3800
SCALE: NONE	SHEET: 1 OF 3

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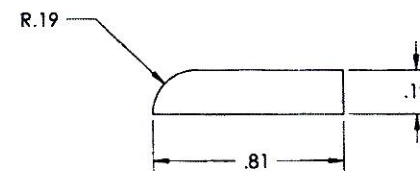
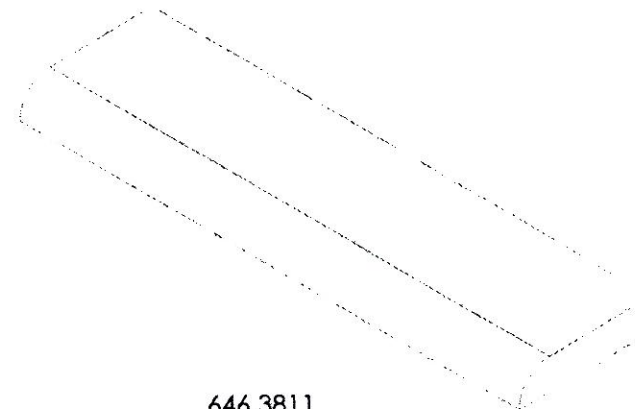
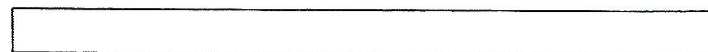
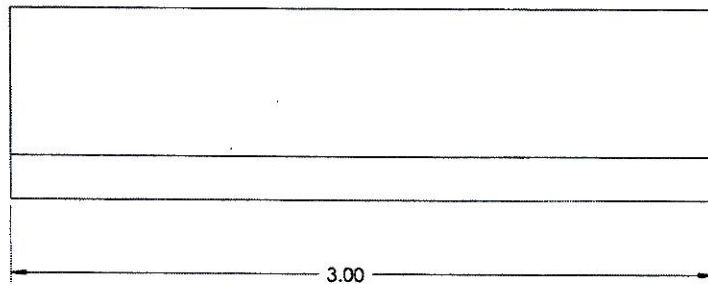
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

A

B

C

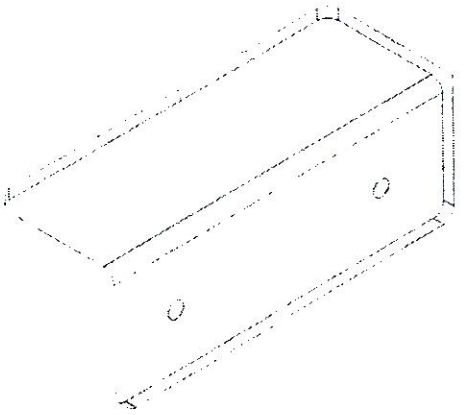
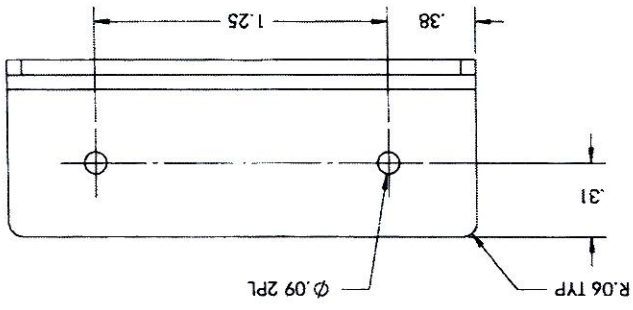
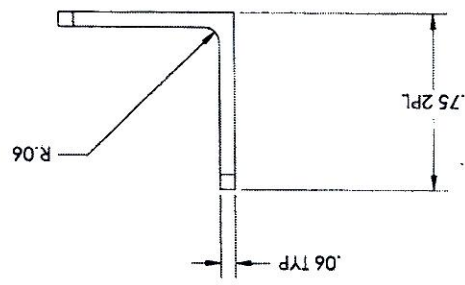
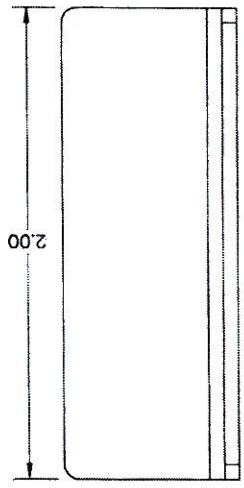
D



NEXT ASSY (S)	ORIGINAL DATE: 06-19-08	APICAL INDUSTRIES	
	MO (DA) (YR)	2608 TEMPLE HEIGHTS DR.	
	DRAWN BY: J. GARDNER	OCEANSIDE, CA. 92056-3512 (760) 724-5300	
	CHECKED:		
	DRAWING APPROVAL:		
	CONTRACT NO:		
	UNLESS OTHERWISE SPECIFIED:		
	DIMENSIONS ARE IN INCHES		
	TOLERANCES ARE:		
	1 PLACE DECIMALS ±.010		
	2 PLACE DECIMALS ±.005		
	*FRACTIONS 1/32"		
	SCALE: NONE	SHEET: 2 OF 3	
		SHEET: 2 OF 3	

APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR.	
OCEANSIDE, CA. 92056-3512 (760) 724-5300	
BRACKETS	
SHEET: 07M26	DWG NO: 646.3800
SCALE: NONE	REV: N/C

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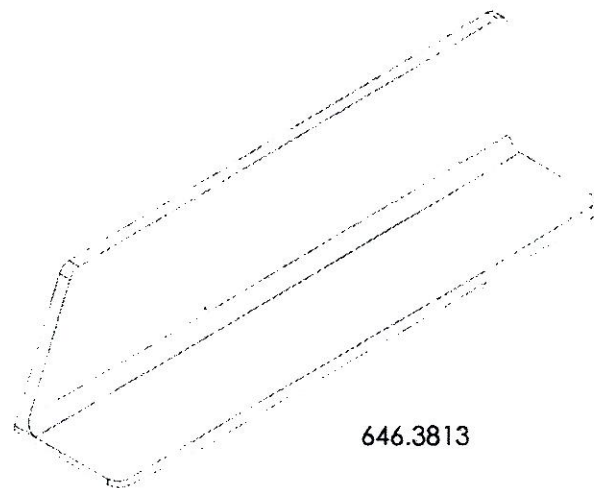
646.3812

APICAL INDUSTRIES		NEXT ASSY IS:	
2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		DRAWN BY: J. HORTON CHECKED BY: J. HORTON DATE: 06-18-05	
BRACKETS		CONTRACT NO.:	
646.3800		LIMIT TO CONTRACT INCREASE:	
N/C		REWORKING AND REWORKS:	
07/06/05		TOLERANCES ARE:	
NONE		FRACTIONAL DECIMALS: .005	
SHEET 3 OF 3		ANGLES: 3°	

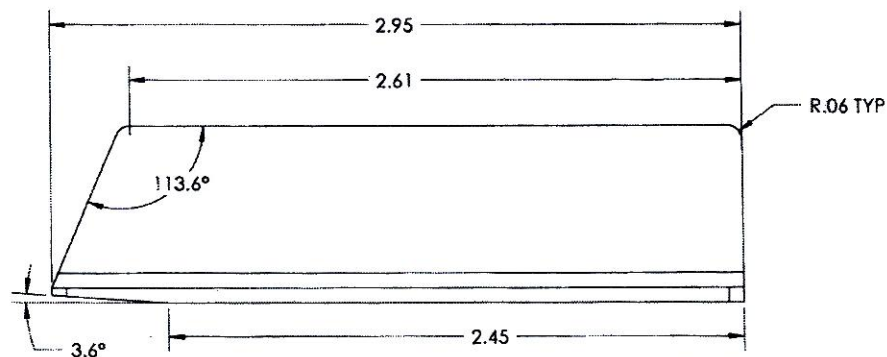
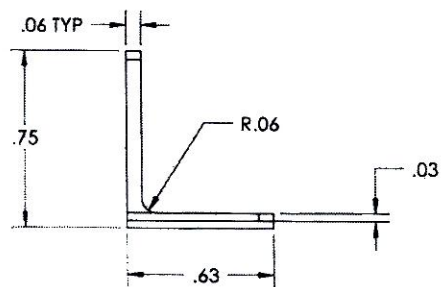
REV.	DESCRIPTION	DATE	APPROVED

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



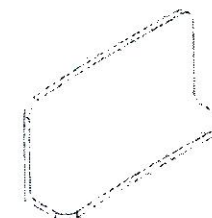
646.3813



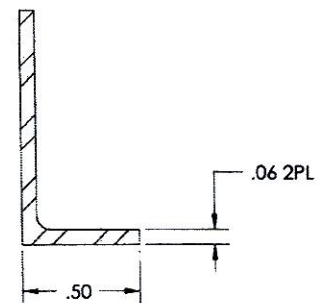
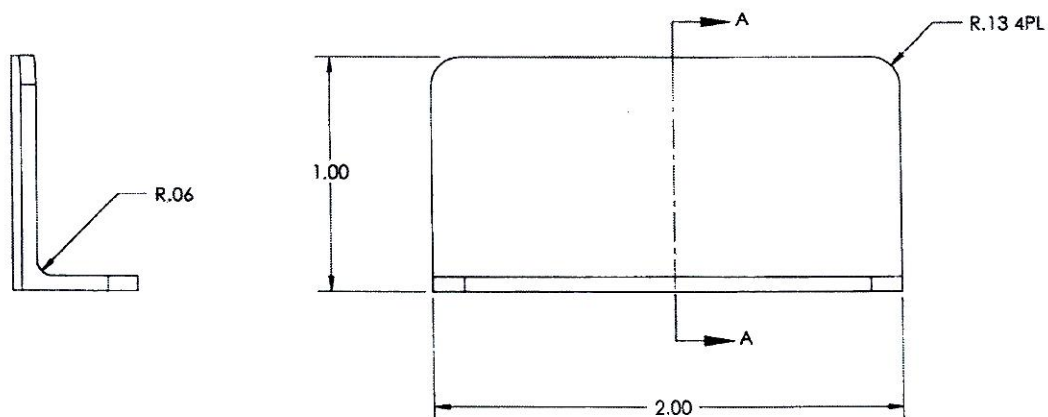
NEXT ASSY (S)	ORIGINAL DATE	08-10-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300			
	DESIGNED BY	ENGINEER				
	1. GARDNER	DRAWING APPROVAL	BRACKETS			
	CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.001 ANGLES ±.5°			THE PACKAGE CODE	DWG NO	REV	
			B 07/AL6	646.3800	N/C	
			SCALE NONE		SHEET 4 OF 5	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



646.3814



SECTION A-A

NEXT ASSY (S)		ORIGINAL DATE 08-16-06	APICAL INDUSTRIES 2606 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWN BY J. CAPORINI		CHECKED		
DATE DESIGNED		DATE VERIFIED	BRACKETS	
CONTRACT NO.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 ANGLES ±.5°		DATE CODE B 07M26	DWG. NO. 646.3800	REV. N/C
SCALE NONE		SHEET 5 OF 5		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34063**

Purchase Order Date 10/26/2016
PO Print Date 10/27/2016

Page Number 5 of 9

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone

613-446-4544

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

VENDOR'S TRUCK

Line Total: \$65.50

12 151651

OAS
38
3-89

646.3811 RADIUS
BLOCK REV. N/C

11/9/2016

Yes

11/9/2016

10.00

\$6.55 \$65.50

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$65.50

13 150127

646.9710 BODY REV. D

11/9/2016

Yes

11/9/2016

10.00

\$14.50 \$145.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$145.00

14 151665

647.0113 STRUT
DOUBLER REV. A

11/9/2016

Yes

11/9/2016

6.00

\$11.75 \$70.50

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Note:

10/27/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912522

Date: 09-Nov-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
12 ea	Part: 646.3714 Gusset Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20317		Rev: A PO: 34063 Line: 10
10 ea	Part: 646.3810 Bracket Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20318		Rev: N/C PO: 34063 Line: 11
10 ea	Part: 646.3811 ✓ Radius Block Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20319		Rev: N/C PO: 34063 Line: 12
10 ea	Part: 646.9710 Body Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20320		Rev: D PO: 34063 Line: 13
6 ea	Part: 647.0113 Strut Doubler Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20321		Rev: A PO: 34063 Line: 14
8	Part: 647.0210		Rev: N/C

DAS
38
9-89

DAS
26
9-89

NOV 11 2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912522

Date: 09-Nov-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
Quantity	Description
DATE : <u>9/11/16</u>	
CERTIFIED SIGNATURE : <u>DAS 26 9-89</u> <u>NOV 11 2016</u>	
RECEIVER SIGNATURE : _____	
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
CERTIFICATE OF CONFORMANCE	
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.	
MADE IN CANADA.	
DAS 38 9-89	